

Work Order ID 122624

Tuesday, July 22, 2014 8:41:59 AM

122624

Ship - and off with -

Page 1

Item ID: D350-607-545

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Quick Release Heli-Utility-Basket™ Short Version Heavy Duty Lid Squirrel Check & Spacepod Compatible

Start Date: 7/15/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/25/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-07-23 Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

D350-607-3

D

DSI9699

A

MLJ 14-09-02

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D350-607-545 CHG007

LABEL ONLY

DAS
06
9-89

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

****Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label ****

1 7/16 14-9-2

DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | |
|--|--|---|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> |
|--|--|---|

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

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|--|--|---|--|

Work Order ID 122624

Tuesday, July 22, 2014 8:41:59 AM

122624

Page 3

Item ID: D350-607-545**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Item Name:** Quick Release Heli-Utility-Basket™ Short Version Heavy Duty Lid Squirrel Check & Spacepod Compatible**Stop *NS2*****Start Date:** 7/15/14 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 7/25/14 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 140 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

MW 1409-04

W. H. H. H.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | |
|--|--|---|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> |
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| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

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|--|--|---|--|

Tuesday, July 22, 2014 8:41:56 AM

122624

D350-607-545

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 10-06-28 JLM VERIFIED BY: LL IPP REV:B
10-08-19 AS PER REV.A DD VERF BY:EC IPP Rev:C 11.02.09
add to install label DD verf by:EC IPP REV:D 12.03.06 AS PER
ECN12-535 DD VERF:EC IPP REV:E 12.07.24 AS PER ECN 12-610
DD VERF:EC IPP REV:F 13.08.21 CHG005 / ECN 13-624 DD
VERF:JLM IPP REV:G 14.06.09 AS PER ECN14-572 DD VERF:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|-----------------|---------------|----------------|--------|
| D4086-220 | | Manufactured | No | | | | Each | 12.0000 | | | | | DAS |
| *D4086-220* | | | | | | | | | ** | | | | 26 |
| Placard | | | | | | | | | | | | | 9-89 |
| | DAS 06 9-89 | | | | <u>Location</u> | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | | | ST091 | | | 12 | | | | | |
| | | | | | 84149 | | | 12 | | | | | |
| D4917-320 | | Manufactured | No | | | | Each | 9.0000 | | | | | DAS |
| *D4917-320* | | | | | | | | | ** | | | | 26 |
| Placard, Max Load | | | | | | | | | | | | | 9-89 |
| | | | | | <u>Location</u> | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | | | ST126 | | | 7 | | | | | |
| | | | | | 112209 | | | 7 | | | | | |
| | | | | | ST127 | | | 2 | | | | | |
| | | | | | 110575 | | | 2 | | | | | |
| D350-607-511 | | Manufactured | No | | | 110 | Each | 2.0000 | 1 | | | | DAS |
| *D350-607-511* | | | | | | | | | ** | | | | 26 |
| Quick Release Basket Mounting Spacepod™ & Squirrel Cheek Fits LH or RH | | | | | | | | | | | | | 9-89 |
| | | | | | <u>Location</u> | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | | | PK15 | | | 2 | | | | | |
| | | | | | 115589 | | | 2 | | | | | |

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | |
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| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> |
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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

Picklist Print

Page 2

Tuesday, July 22, 2014 8:41:57 AM

Work Order ID: 122624

122624

Parent Item: D350-607-545

D350-607-545

Parent Item Name: Quick Release Heli-Utility-Basket™ Short Version Heavy Duty Lid Squirrel
Cheek & Spacepod Compatible

Start Date: 7/15/14

Required Date: 7/25/14

D2690-6 Manufactured No

110 Each

76.0000

Start Qty: 1.00

Required Qty: 1.00

D2690-6

Lanyard

**

DAS

26

9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST009

76

102246

4

115851

2

117190

29

120529

20

121163

15

121864

6

D3912-041

Manufactured No

110 Each

8.0000

D3912-041

Eyebolt Receiver Assy

**

DAS

26

9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST065

8

115569

1

115570

3

115572

4

D4032-041

Manufactured No

110 Each

0.0000

D4032-041

Short Basket Assembly (350)

DAS
06
9-89

**

DAS

26

9-89

D4151-041

Manufactured No

110 Each

0.0000

D4151-041

Basket Fwd Hardpoint Assembly, Lower

**

DAS

26

9-89

DAS
06
9-89

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

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|--|--|---|--|

Picklist Print

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Parent Item: D350-607-545

D350-607-545

Parent Item Name: Quick Release Heli-Utility-Basket™ Short Version Heavy Duty Lid Squirrel
Cheek & Spacepod Compatible

Start Date: 7/15/14

Required Date: 7/25/14

D4151-043 Manufactured No

110 Each

11.0000

Start Qty: 1.00

Required Qty: 1.00

DAS
26
9-89

D4151-043

Basket Fwd Hardpoint Assembly, Upper

DAS
06
9-89

Location

Loc Qty

Loc Code

ST096

11

116111

4

116112

3

120541

4

** 7/15/14 7/25/14

D4150-041 Manufactured No

110 Each

8.0000

1

1

DAS
26
9-89

D4150-041

Attachment Arm Assembly

Location

Loc Qty

Loc Code

ST095

8

115999

2

116000

4

116003

2

** 7/15/14 7/25/14

AN4-13A Purchased No

110 Each

967.0000

6

6

DAS
26
9-89

AN4-13A

Bolt

DAS
06
9-89

Location

Loc Qty

Loc Code

CA

2

m129682

2

FG

20

122808

20

GA

14

m125709

14

ST515

931

m127432

36

m127817

24

m128403

4

m128739

867

** 7/15/14 7/25/14

6

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|--|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

Picklist Print

Page 4

Tuesday, July 22, 2014 8:41:57 AM

Work Order ID: 122624

122624

Parent Item: D350-607-545

D350-607-545

Parent Item Name: Quick Release Heli-Utility-Basket™ Short Version Heavy Duty Lid Squirrel
Cheek & Spacepod Compatible

Start Date: 7/15/14

Required Date: 7/25/14

| | | | | | | | | |
|-----------------|-----------|----|-----|------|----------|-----------------|--------------------|------|
| AN4C15 | Purchased | No | 110 | Each | 104.0000 | Start Qty: 1.00 | Required Qty: 1.00 | DAS |
| *AN4C15* | | | | | | ** | 1 | 26 |
| Bolt | | | | | | | | 9-89 |

DAS
06
9-89

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST357 | 50 | |
| M128634 | 50 | |
| ST517a | 54 | |
| M125716 | 4 | |
| M128936 | 50 | |

| | | | | | | | | |
|------------------|-----------|----|-----|------|----------|-----------------|--------------------|------|
| AN310C4 | Purchased | No | 110 | Each | 124.0000 | Start Qty: 1.00 | Required Qty: 1.00 | DAS |
| *AN310C4* | | | | | | ** | 1 | 26 |
| Nut | | | | | | | | 9-89 |

DAS
06
9-89

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST331 | 124 | |
| M125952 | 1 | |
| M127817 | 21 | |
| M128489 | 2 | |
| M128739 | 50 | |
| M128936 | 50 | |

| | | | | | | | | |
|-----------------------|-----------|----|-----|------|---------|-----------------|--------------------|------|
| MS17984-C413 | Purchased | No | 110 | Each | 71.0000 | Start Qty: 1.00 | Required Qty: 1.00 | DAS |
| *MS17984-C413* | | | | | | ** | 1 | 26 |
| Quick Release Pin | | | | | | | | 9-89 |

DAS
06
9-89

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST316 | 71 | |
| m126872 | 1 | |
| m129795 | 20 | |
| m129796 | 50 | |

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | |
|---|--|---|---|--|---|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | <table style="width: 100%;"> <tr> <td style="width: 33%;"> AGAINST DEPARTMENT/PROCESS Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </td> <td style="width: 33%;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </td> <td style="width: 33%;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </td> <td style="width: 33%;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </td> </tr> </table> | AGAINST DEPARTMENT/PROCESS Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> | Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> | Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> | Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> |
| AGAINST DEPARTMENT/PROCESS Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> | Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> | Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> | Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

Picklist Print

Tuesday, July 22, 2014 8:41:57 AM

Work Order ID: 122624

122624

Parent Item: D350-607-545

D350-607-545

Parent Item Name: Quick Release Heli-Utility-Basket™ Short Version Heavy Duty Lid Squirrel
Cheek & Spacepod Compatible

Start Date: 7/15/14

Required Date: 7/25/14

| | | | | | | | | |
|--------------------|-----------|----|-----|------|-----------|----------------------|-------------------------|----------------------|
| MS21042L4 | Purchased | No | 110 | Each | 4,497.000 | Start Qty: 1.00 6 | Required Qty: 1.00 6 | DAS 26 9-89 |
| *MS21042L4* | | | | | | ** ✓ | <i>NG</i> ✓ | MS21042L4 |
| Locknut | | | | | | | | |

DAS
06
9-89

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST307 | 4497 | |
| 126275 | 5 | |
| m126015 | 12 | |
| m126275 | 27 | |
| m127255 | 71 | |
| m127376 | 11 | |
| m127813 | 891 | |
| m128300 | 80 | |
| m128798 | 2400 | |
| m129472 | 1000 | |

MS24665-151

Purchased No

110 Each

186.0000

1

1

DAS
26
9-89

MS24665-151

Cotter Pin

** ✓

NG ✓

~~MS24665-151~~

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST297 | 186 | |
| 125646 | 1 | |
| 17566 | 4 | |
| m128401 | 181 | |

DAS
36
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

Picklist Print

Tuesday, July 22, 2014 8:41:57 AM

Work Order ID: 122624

122624

Parent Item: D350-607-545

D350-607-545

Parent Item Name: Quick Release Heli-Utility-Basket™ Short Version Heavy Duty Lid Squirrel
Cheek & Spacepod Compatible

Start Date: 7/15/14

Required Date: 7/25/14

NAS1515H4L

Purchased

No

110

Each

440.0000

Start Qty: 1.00

Required Qty: 1.00

***NAS1515H4I ***

Washer

**

DAS

26

9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

FG

32

103691

32

ST273

408

123560

18

125654

2

m127432

14

m127831

124

m128635

250

NAS1149F0432P

Purchased

No

110

Each

2,142.000

12

12

NAS1149F0432P

WASHER

**

DAS
26
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST275

2142

125268

40

M126221

57

M127813

3

M128429

1286

M128591

6

M128995

750

NAS1149C0463R

Purchased

No

110

Each

707.0000

3

3

NAS1149C0463R

Washer

**

DAS
26
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST278

707

119097

1

123248

1

123355

55

m127306

150

m128401

500

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | |
|--|--|---|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> |
|--|--|---|

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-607-3 Rev.D,
INSTALLATION INSTRUCTIONS D350-607-4 Rev. C AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-607 REV. 6
REF TCCA STC: SH94-14
REF FAA STC: SR00213NY
REF EASA STC: EASA.10016996
REF BRAZILIAN STC: 2007S03-03/-04/-05/-06

NO. 122624M15
14-07-23
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
ENGINEERING
RETURN TO
N/AOP COPY

1.0 PURPOSE

This service instruction provides parts and instructions to facilitate installation of forward Basket Strut for customers that have purchased: D350-607-501 Conversion Kit @ CHG 004, D350-607-511 Quick Release Basket Mounting Kit @ CHG 004, D350-607-541 @ CHG 006, D350-607-543 @ CHG 007, D350-607-545 @ CHG 006, D350-607-547 @ CHG 007 Heli-Utility-Baskets as well as the D350-607-431 Strut Retrofit Kit and the D350-607-641 Long Cargo Tube @ CHG 001.

2.0 PARTS LIST:

Modify the quantities for D3910-5 and add D3910-7 as follows:

| QTY -541 | QTY -543 | QTY -545 | QTY -547 | QTY -511 | QTY -501 | PART NUMBER | DESCRIPTION |
|-------------|-------------|-------------|-------------|-------------|-------------|--------------|--|
| X | | | | | | D350-607-541 | HELI-UTILITY-BASKET @ CHG 007 OR LATER |
| | X | | | | | D350-607-543 | HELI-UTILITY-BASKET @ CHG 008 OR LATER |
| | | X | | | | D350-607-545 | HELI-UTILITY-BASKET @ CHG 007 OR LATER |
| | | | X | | | D350-607-547 | HELI-UTILITY-BASKET @ CHG 005 OR LATER |
| 1 | 1 | 1 | 1 | X | | D350-607-511 | QUICK RELEASE BASKET MOUNTING KIT @ CHG 005 OR LATER |
| | | | | | X | D350-607-501 | CONVERSION KIT @ CHG 005 OR LATER |
| | | | | 1 | 1 | D3910-5 | X-TUBE LUG |
| | | | | 1 | 1 | D3910-7 | X-TUBE LUG |

(ADD)

| QTY -413 | QTY -415 | QTY -417 | QTY -419 | QTY -431 | PART NUMBER | DESCRIPTION |
|-------------|-------------|-------------|-------------|-------------|--------------|---------------------------------------|
| X | | | | | D350-607-413 | HEAVY DUTY LID KIT (LONG) |
| | X | | | | D350-607-415 | HEAVY DUTY LID KIT (SHORT) |
| | | X | | | D350-607-417 | LIGHTWEIGHT LID KIT (LONG) |
| | | | X | | D350-607-419 | LIGHTWEIGHT LID KIT (SHORT) |
| | | | | X | D350-607-431 | STRUT RETROFIT KIT @ CHG 005 OR LATER |
| | | | | 1 | D3910-5 | X-TUBE LUG |
| | | | | 1 | D3910-7 | X-TUBE LUG |

(ADD)




| QTY -641 | QTY -611 | QTY -511 | QTY -431 | PART NUMBER | DESCRIPTION |
|-------------|-------------|-------------|-------------|--------------|--|
| X | | | | D350-607-641 | QUICK RELEASE LONG CARGO TUBE |
| 1 | X | | | D350-607-611 | LONG CARGO TUBE |
| 1 | | X | | D350-607-511 | QUICK RELEASE BASKET MOUNTING KIT @ CHG 005 OR LATER |
| | | | X | D350-607-431 | STRUT RETROFIT KIT @ CHG 005 OR LATER |
| | | 1 | 1 | D3910-5 | X-TUBE LUG |
| | | 1 | 1 | D3910-7 | X-TUBE LUG |

(ADD)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 14.05.16
CERT. NO.: SH94-14
ISSUE NO.: 6

| | | | |
|------------|---|--|--------------|
| A | NEW ISSUE | AJS | 14.05.16 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED |  | DRAWING NO. | REV. A |
| MFG. APPR. | N/A | DSI 9699 | SHEET 1 OF 2 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | LUG REPLACEMENT | NTS |
| DATE | 14.05.16 | COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

3.0 PROCEDURE:

Install the D350-607-501 Conversion Kit, D350-607-511 Quick Release Mounting Kit or D350-607-431 Strut retrofit kit per Installation Instructions D350-607-3 Rev. D or D350-607-4 Rev. C. While installing the Forward Strut perform the following:

3.1 Substitute the Forward Lower D3910-5 X-Tube Lug with the D3910-7 X-Tube Lug as shown in Figure 1.

3.2 Install the forward D4775-041 Strut Assembly. Transfer mark from the upper hole on the clevis of the D4775-041 Strut Assembly to the D3910-7 X-tube Lug and drill thru the lug $\varnothing 0.257 - \varnothing 0.261$ as shown in Figure 1. Touch up chemical conversion coating per MIL-DTL-5541. Check the witness holes located at the bottom end of the D4775-041 Strut Assemblies to ensure that the thread from the rod end extends past the witness hole.
Torque MS21042L4/-4 nuts to 50-70 in-lbs (5.7-7.9 N-m). Torque MS21042L6/-6 nuts to 160-190 in-lbs (18.1-21.5 N-m).

3.3 Complete the installation in accordance with Installation Instructions D350-607-3 Rev. D or D350-607-4 Rev. C.

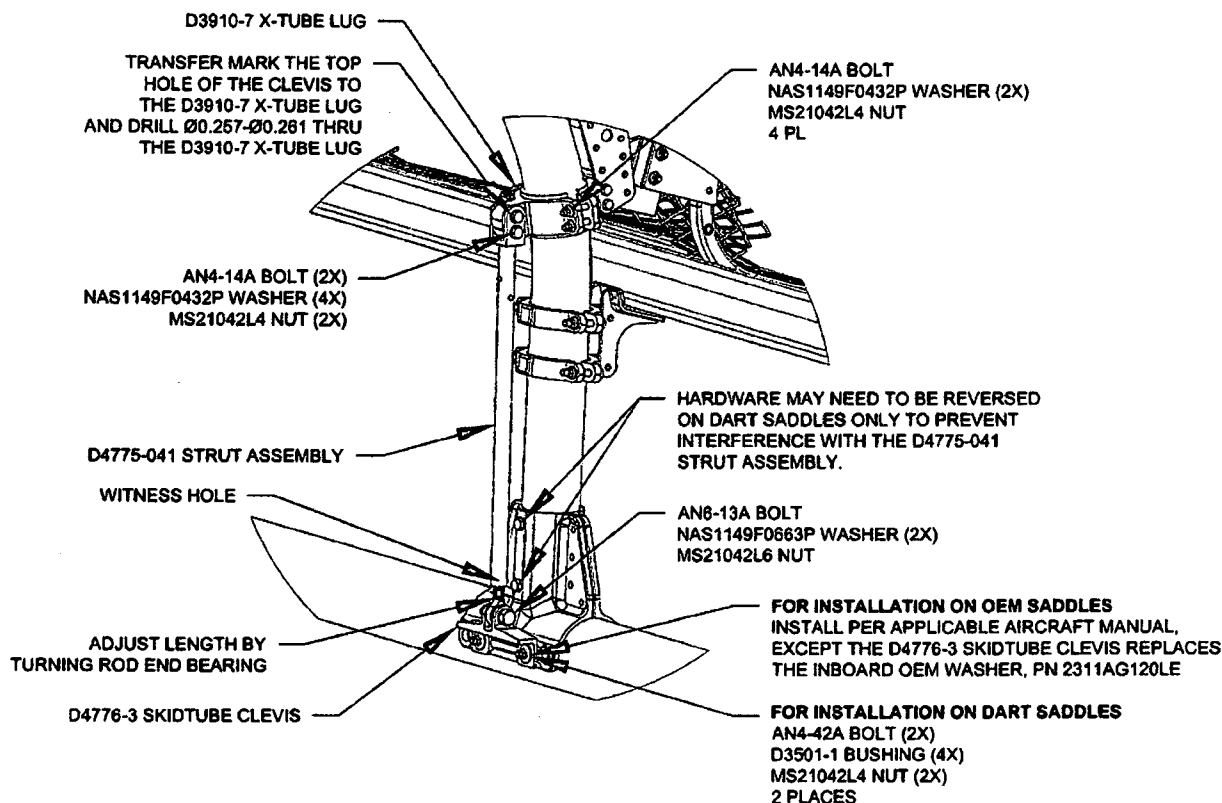


FIGURE 1: INSTALLATION OF D4775-041 FWD STRUT

4.0 WEIGHT AND BALANCE:

There is no weight and balance change associated with this update.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.05.16
CERT. NO.: SH94-14
ISSUE NO.: 6

| | | | |
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| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. A |
| MFG. APPR. | N/A | DSI 9699 | SHEET 2 OF 2 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | LUG REPLACEMENT | NTS |
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5.0 PARTS LIST

| QTY -541 | QTY -543 | QTY -545 | QTY -547 | QTY -511 | QTY -501 | PART NUMBER | DESCRIPTION |
|-------------|-------------|-------------|-------------|-------------|-------------|---------------|-----------------------------------|
| X | | | | | | D350-607-541 | HELI-UTILITY-BASKET |
| | X | | | | | D350-607-543 | HELI-UTILITY-BASKET |
| | | X | | | | D350-607-545 | HELI-UTILITY-BASKET |
| | | | X | | | D350-607-547 | HELI-UTILITY-BASKET |
| 1 | 1 | 1 | 1 | X | | D350-607-511 | QUICK RELEASE BASKET MOUNTING KIT |
| | | | | | X | D350-607-501 | CONVERSION KIT |
| 1 | 1 | 1 | 1 | | 1 | D2690-6 | LANYARD |
| | | | | 8 | 8 | D3501-1 | BUSHING |
| | | | | 2 | 2 | D3910-3 | X-TUBE LUG |
| | | | | 2 | 2 | D3910-5 | X-TUBE LUG |
| 1 | 1 | 1 | 1 | | 1 | D3912-041 | EYEBOLT RECEIVER ASSY |
| | | | | 8 | 8 | D3984-030 | RUBBER EXTRUSION, X-TUBE |
| 1 | | | | | | D4030-041 | LONG BASKET ASSY |
| | 1 | | | | | D4030-043 | LONG BASKET ASSY, LIGHTWEIGHT |
| | | 1 | | | | D4032-041 | SHORT BASKET ASSY |
| | | | 1 | | | D4032-043 | SHORT BASKET ASSY, LIGHTWEIGHT |
| 1 | | | | | 1 | D4917-300 | PLACARD, MAX LOAD |
| 1 | | | | | | D4086-200 | PLACARD, MAX LOAD |
| | 1 | | | | 1 | D4917-315 | PLACARD, MAX LOAD |
| | 1 | | | | | D4086-215 | PLACARD, MAX LOAD |
| | | 1 | | | 1 | D4917-320 | PLACARD, MAX LOAD |
| | | 1 | | | | D4086-220 | PLACARD, MAX LOAD |
| | | | 1 | | 1 | D4917-332 | PLACARD, MAX LOAD |
| | | | 1 | | | D4086-232 | PLACARD, MAX LOAD |
| | | | | 1 | 1 | D4148-041 | FWD X-TUBE LUG ASSY |
| | | | | 1 | 1 | D4149-041 | AFT X-TUBE LUG ASSY |
| 1 | 1 | 1 | 1 | | 1 | D4150-041 | ATTACHMENT ARM ASSY |
| 1 | 1 | 1 | 1 | | 1 | D4151-041 | BASKET FWD HARDPOINT ASSY (LOWER) |
| 1 | 1 | 1 | 1 | | 1 | D4151-043 | BASKET FWD HARDPOINT ASSY (UPPER) |
| | | | | 2 | 2 | D4775-041 | STRUT ASSEMBLY |
| | | | | 2 | 2 | D4776-3 | SKIDTUBE CLEVIS |
| 6 | 6 | 6 | 6 | | 6 | AN4-13A | BOLT |
| | | | | 20 | 22 | AN4-14A | BOLT |
| | | | | 4 | 4 | AN4-42A | BOLT |
| 1 | 1 | 1 | 1 | | 1 | AN4C15 | BOLT |
| 1 | 1 | 1 | 1 | | 1 | AN310C4 | CASTELLATED NUT |
| | | | | 2 | 2 | AN6-13A | BOLT |
| 1 | 1 | 1 | 1 | | 1 | MS17984-C413 | QUICK RELEASE PIN |
| 6 | 6 | 6 | 6 | 24 | 32 | MS21042L4 | NUT (OR MS21042-4) |
| | | | | 2 | 2 | MS21042L6 | NUT |
| 1 | 1 | 1 | 1 | | 1 | MS24665-151 | COTTER PIN |
| 2 | 2 | 2 | 2 | | 2 | NAS1515H4L | WASHER |
| 12 | 12 | 12 | 12 | 40 | 56 | NAS1149F0432P | WASHER |
| 3 | 3 | 3 | 3 | | 3 | NAS1149C0463R | WASHER |
| | | | | 4 | 4 | NAS1149F0663P | WASHER |